

Work Order ID 77000

77000

Page 1

November-24-11 2:49:52 PM

Item ID: D3405-041

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Lug Assembly

Start Date: 24/11/2011 Start Qty: 10.00

10

Cust Item ID:

Required Date: 08/12/2011 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: M.C.J

Date: 11/11/24

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D3405

Rev B

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3405

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

11-11-29

(14)

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

11-11-29

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

W

11

11

29

(14)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC - Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

Work Order ID 77000

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Page 2

November-24-11 2:49:52 PM

Item ID: D3405-041 Accept ***N9000040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Lug Assembly
 Start Date: 24/11/2011 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 08/12/2011 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130 *130* Brake NC Brake NC | NC BRAKE Memo 1-Deburr 2-Form using DT8204 as per Dwg D3405 3- use DT9681 to check if correct forming | 0.00 0.00 | | | | (14) | | | |
| 140 *140* QC Quality Control | QC5- Inspect part completeness to step on W/O Memo | 0.00 0.00 | | | | (14) | | | |
| 150 *150* Large Fab Large Fab | Large Fab Memo Weld as per Dwg D3405 use DT8484 Identify as D3405-041 | 0.00 0.00 | | | | | | | |

SB 11/12/14

S 11/12/16

Q 11-12-22 (14)

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 77000

77000

Page 3

November-24-11 2:49:52 PM

Item ID: D3405-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Lug Assembly
Start Date: 24/11/2011 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 08/12/2011 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| | | | | | | | | | |
|-----------------|--|------|--|--|--|--|--|--|--|
| 160 | QC9- Inspect visual per QSI004- Fusion Welds | 0.00 | | | | | | | |
| *160* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

| | | | | | | | | | |
|-----------------|---|------|--|--|--|--|--|--|--|
| 170 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| *170* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

| | | | | | | | | | |
|----------------|---|------|--|--|--|--|--|--|--|
| 180 | White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel | 0.00 | | | | | | | |
| *180* | | | | | | | | | |
| Powdercoat | Memo | 0.00 | | | | | | | |
| Powder Coating | | | | | | | | | |

M119480

START TIME: 9:20
OVEN TEMPERATURE: 400°F
FINISH TIME: 9:50

14X Ø M-12/01/05

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 77000

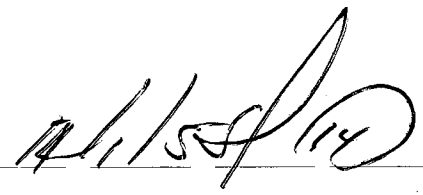
77000

Page 4

November-24-11 2:49:52 PM

Item ID: D3405-041 Accept ***N9000040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Lug Assembly
 Start Date: 24/11/2011 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 08/12/2011 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|--|----------------------|---------|--------|--------------|---------------|---------------|----------------------------|--|
| 190 *190* QC Quality Control | QC3- Inspect Part Finish Memo | 0.00 0.00 | | | | 14 | BL | 12-1-5. | |
| 200 *200* Packaging Packaging | Identify as per dwg & Stock Location: 4/8 Memo | 0.00 0.00 | | | | | | |  |
| 210 *210* QC Quality Control | QC21- Final Inspection - Work Order Release Memo | 0.00 0.00 | | | | OK | | 12/01/05 MF 12-01-05 | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

November-24-11 2:49:56 PM

Page 1

Work Order ID: 77000

77000

Parent Item: D3405-041

D3405-041

Parent Item Name: Lug Assembly

Start Date: 24/11/2011

Required Date: 08/12/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP A05.09.01New issueKJ/JLM
IPP B 09.01.28 rev.B drawing EC verified by:DD

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

| | | | | | | | | | | | | | |
|-----------|--|--------------|----|--|--|-----|------|---------|----|----|--|------------|--|
| D3404-1 | | Manufactured | No | | | 100 | Each | 47.0000 | 1 | 10 | | | |
| *D3404-1* | | | | | | | | | ** | | | 2 11-12-22 | |
| GHW Lug | | | | | | | | | | | | | |

76994x10

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| WA | 7 | |
| 70664 | 7 | |
| WA030 | 40 | |
| 72326 | 5 | |
| 74551 | 35 | |

M304S11GA

Purchased No

M304S11GA

304/316 0.125 Sheet

| | | | | |
|-----|----|---------|-------|----------|
| 150 | sf | 93.3000 | 0.154 | 1.621053 |
|-----|----|---------|-------|----------|

**

2.2
B1-11-29

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| MAT020 | 93.3 | |
| 119006 | 41.5 | |
| 119048 | 51.8 | |

119048

(14)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

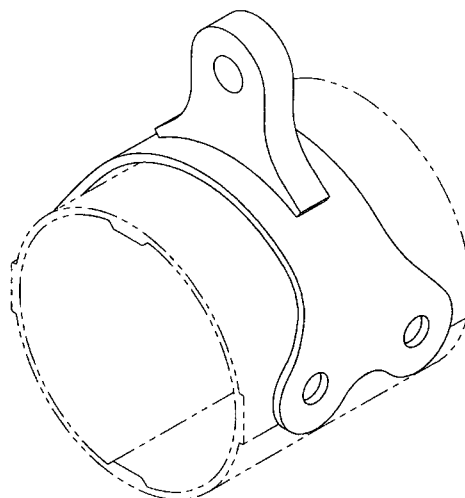
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
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NOTE: Date & initial all entries

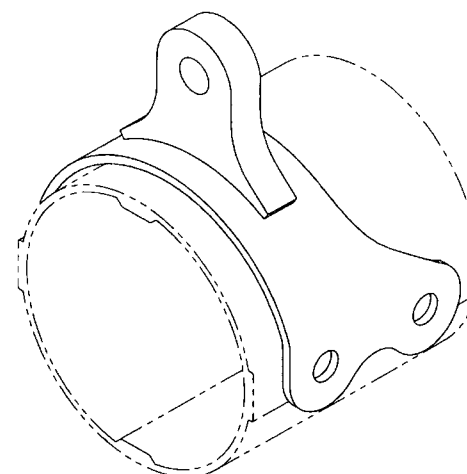
| ITEM No. | QTY. -041 | QTY. -043 | PART NUMBER | DESCRIPTION |
|----------|-----------|-----------|-------------|--------------|
| 1 | X | | D3405-041 | LUG ASSEMBLY |
| 2 | | X | D3405-043 | LUG ASSEMBLY |
| 11 | 1 | 1 | D3404-1 | GHW LUG |
| 12 | 1 | | D3405-1 | GHW BRACKET |
| 13 | | 1 | D3405-3 | GHW BRACKET |

B

SHOP ONLY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 77000



D3405-041 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)



D3405-043 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)

RELEASED
08/12/18

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3405-041" USING FINE POINT PERMANENT INK MARKER
IDENTIFY WITH DART P/N "D3405-043" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: -041, 0.85 lbs
-043, 0.87 lbs

| | | | | |
|------------|--|--|--------------|----------|
| B | DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERNS FOR -1 & -3 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR198). SHEETS 3 & 4 ZONE A6 4.120 DIM WAS 4.100. | | AJS | 08.09.19 |
| A | NEW ISSUE | | PH | 05.03.08 |
| REV. | DESCRIPTION | | BY | DATE |
| DESIGN | PH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | |
| DRAWN | AJS | | | |
| CHECKED | | DRAWING NO. | REV. B | |
| MFG. APPR. | | D3405 | SHEET 1 OF 4 | |
| APPROVED | | TITLE | SCALE | |
| DE APPR. | | GHW LUG ASSEMBLY | NTS | |
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Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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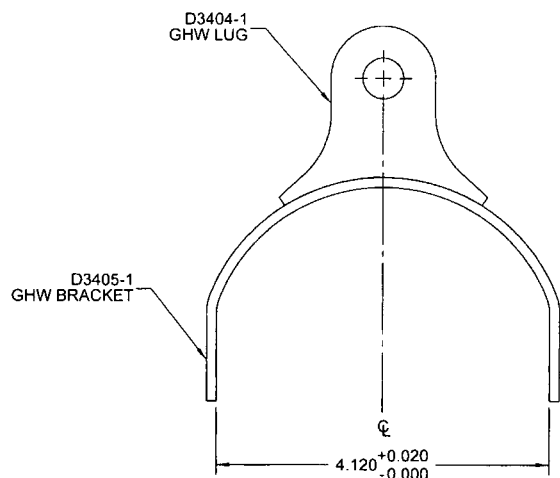
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

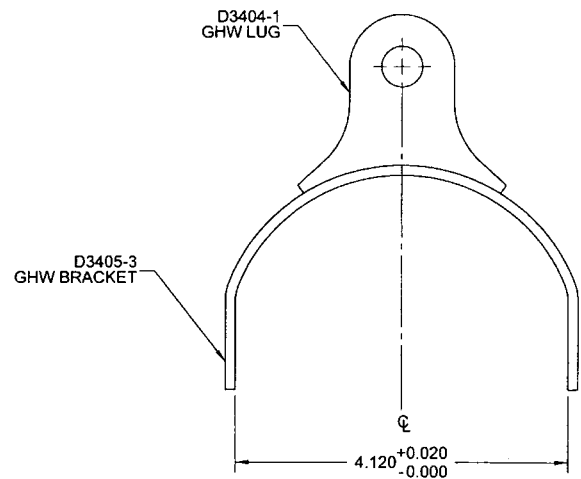
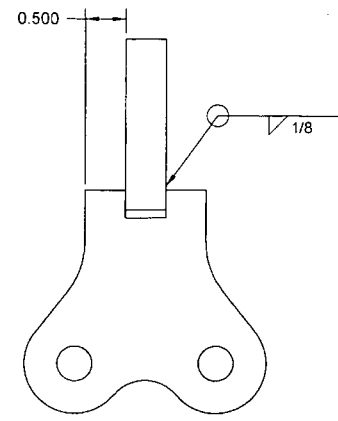
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NOTE: Date & initial all entries

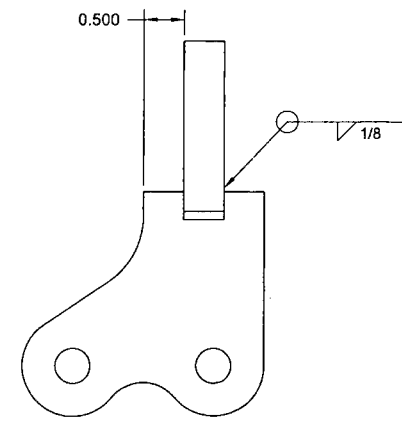
77000



D3405-041 LUG ASSEMBLY



D3405-043 LUG ASSEMBLY



RELEASED
06/12/18

| | | | |
|------------|----------|---|--------------|
| DESIGN | PH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | AJS | | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. | | D3405 | SHEET 2 OF 4 |
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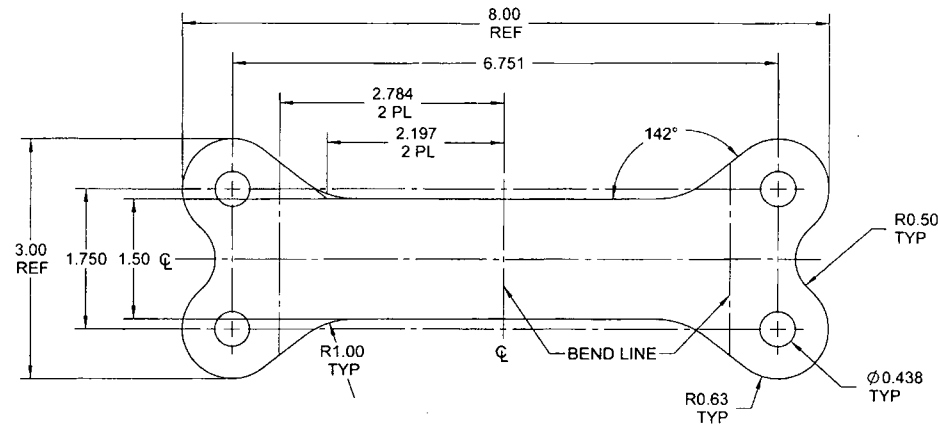
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

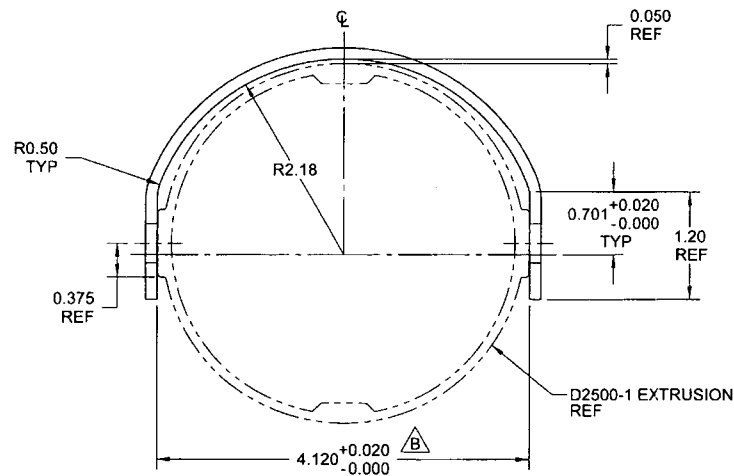
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NOTE: Date & initial all entries

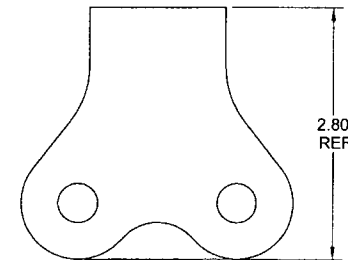
77000



D3405-1F GHW BRACKET FLAT PATTERN



D3405-1 GHW BRACKET
(MAKE FROM D3405-1F)



SIDE VIEW FOR REF ONLY

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S11GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

| | | | |
|------------|----------|---|--------------|
| DESIGN | PH | DART AEROSPACE LTD | |
| DRAWN | AJS | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. | | D3405 | SHEET 3 OF 4 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | GHW LUG ASSEMBLY | NTS |
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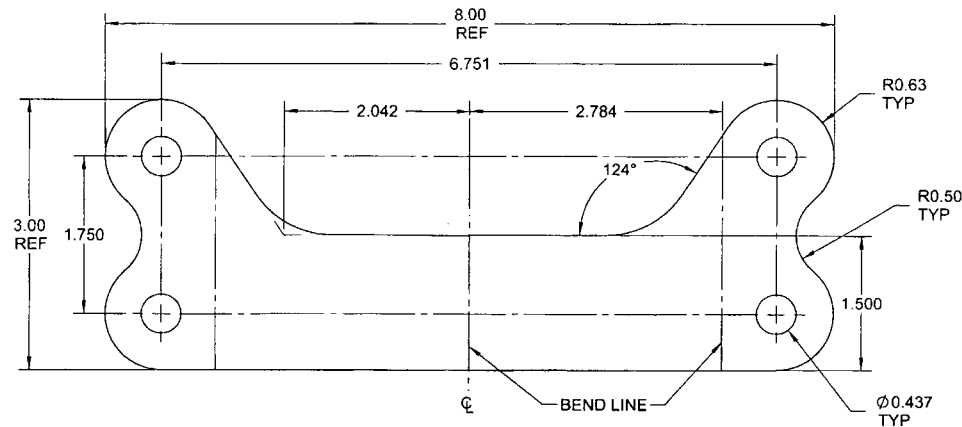
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

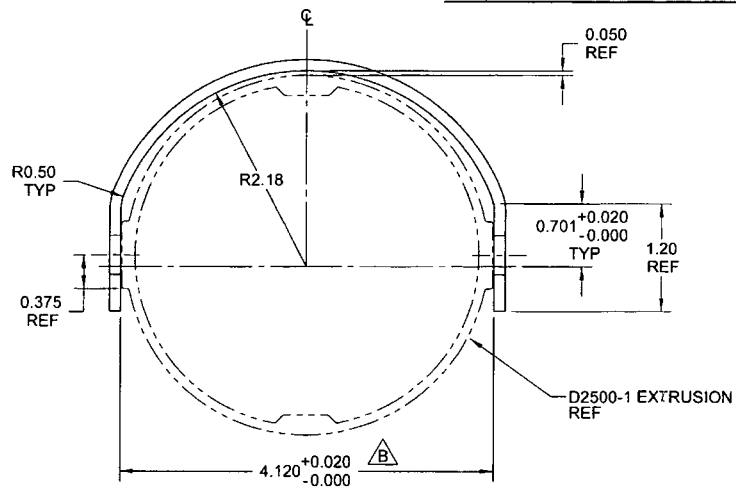
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NOTE: Date & initial all entries

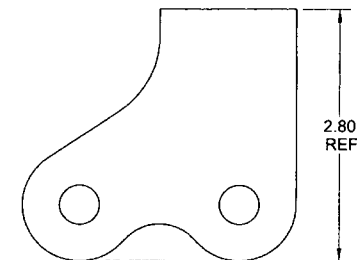
77000



D3405-3F GHW BRACKET FLAT PATTERN



D3405-3 GHW BRACKET
(MAKE FROM D3405-3F)



SIDE VIEW FOR REF ONLY

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S11GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

RELEASED
08/12/18

| | | | |
|------------|----------|--|--------------|
| DESIGN | PH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | AJS | | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. | | D3405 | SHEET 4 OF 4 |
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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries